	er ID 123786 st 21, 2014 1:46:30 PM		*123	3786*	۸٠.	Sh	y no	Page	7		
Item ID: Revision ID: Item Name:	D3463-042 Step Weldment Assembly		Accept	*N900	040	100	<b>7*</b> s	Setup Sta	171	S1* S2*	
	8/21/2014 <b>Start Qty:</b> 2.00	*9*		Cust Item 1 Customer:					··IVI	<b>5</b> /"	
Approvals:	Process Plan:	Date: 14-8-21			ate:		R	tun Sta	~IVI	R1* R2*	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr									Δ.	
D3463	Rev B									14-	08-31
*1 \\ \*\ Large Fab	Weld asse	n 125054) 126 of embly as per dwg D3463 usin a small none welded area on er***	g DT8875	163-3 step to			2				JBC -
110 *110* OC	QC9- Inspect visual po	er QSI004- Fusion Welds	0.00		*		<b>D</b>	14-8	X8-26		DAS 9 - <sub>9-89</sub>
Quality Control	·										
120 *120*	QC5- Inspect part con	npleteness to step on W/O	0.00				2			DAS <b>38</b>	14-8-27
QC	Memo		0.00						_	- <del></del>	_

Memo

Quality Control

DQA:	: Date:											
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	E			_ AEROSPACE
QA Closed:		Date:						· · · · · · · · · · · · · · · · · · ·	Wo	ork Order up	date only	
Work Orde	er:				DISPOSITION			AGA	AINST DE	PARTMENT	PROCESS	
					Rework	)		Skid-tube Cross	stube		Water Jet	Engineering
Part N	lo.				Scrap			<del>  </del>	ıll Fab	Prod	d. Eng. Coor.	Quality
					Use-as-is		Therr	noforming Fini	ishing	Rec/Stor	e/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab Comp	oosite		Supplier	
Root				Desci	ription of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design ·												
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material					·							1.
Operator												
Offset/Setup												
Process	_											
Supplier	_											
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Unapproved												
51.72						FAL	ULT CA	TEGORY				
Landir - ⊶ - [	ng Gear			_	General		1			; [	_	<b>-</b>
}	Bending			<u> </u>	Bend		1	Program		Outside Dime	<b>├</b>	Pressure/Forced
}	Centre No	ot Concei	ntric		BOM/Route		Grain		ļļ	Over/Under	<b>)</b> ——	Set-up
}	Cracks	1 (0: 1	4	-	Broken/Damage/Defect		Hardwa		.	Part Incorrec		Temperature/Cure
	Crimp/Kir	nk/Ripple	e/Wave	-	Burrs	$\vdash$	1	ion Incomplete/Unqualified	$\vdash$	Part Lost/Mis		Weld
	Cuffs			-	Contamination	-	4	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushing			-	Countersink	-	1 7	gned/off center		Positioned W	<u> </u>	ا ا
	Heat Treat			<u> </u>	Cut Too Short		Mislabe			Power Loss/S	urge	Other
	Inspection Strip in Tube				Drawing Drill Holos	⊢	Misread					
	Marks/Ch			-	Drill Holes	-	Off-set				<del></del>	
}	Turning S			-	Finish	<u> </u>	1	Calibration				
	Wave/Tw	rist in Tub	oe		Fit/Function	1	Out of S	Sequence				

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Work Orde				*123				Page 2				
Item ID: Revision ID: Item Name:	D3463-042 Step Weldmer 8/21/2014		*2* *2*	Accept	*NOOO  Cust Item I  Customer:		100	<b>)</b> *	Setup	Start Stop	*N.9	S1* S2*
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*NF	
Sequence ID/ Work Center II  130  *120* Powdercoat  Powder Coating	D	START TIM	as indicated in dwa p340 E: PERATURE: 100		Tool ID	Tool#	Plan Code	Accept Qty	Qty	Ī	Number	Insp. Stamp
140 <b>*1 1 1 1 1 1 1 1 1 1 </b>		Wing Walk as per dwg Q  Memo		29 E01001 0.00			χZ	4	<u>H</u>	_	14/08	29

150

\*150\*

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

DQA: Date:						WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:			WORK ORDER NOW	-00		NVIANCE / C		ork Order up	odate only		AEROSPACE
Work Orde	er:				•	DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
Part N	- No					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Desc	ription of work order update		nitial	A	ction	Sign &			
Cause		Date	Step	Qty		or non-conformance		ief Eng		cription	Date	Verification	ı	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	3													
							FAI	ULT CAT	regory					
Landing Gear  Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence			General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	on Incomplete/lions Incomplete, ions Incomplete, ined/off center iled	/Unclear	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	31	Pressure/Forced Set-up Femperature/Cure Weld Wrong Stock Pulled Other			
}	Turning Sequence Wave/Twist in Tube					Finish Fit/Function	-	ł	Calibration Sequence					
						1.19. 0.10001	L	Loucois	requence					

												:
Work Ord Thursday, Augu				*129	3786*			Page 3	-			
Item ID: Revision ID: Item Name:	D3463-042 Step Weldmen	nt Assembly		Accept	*N900	<b>040</b>	100	<b>)*</b> s	Setup Start Stop	. 1 /	S1* S2*	
Start Date: Required Date: Reference:	8/21/2014	Start Qty: 2.00 Req'd Qty: 2.00	*9*		Cust Item I Customer:	D:				14	. 17	
Approvals:	Process Pla	nn:	Date:	Tooling: _ SPC (Y/N):		ate:		R	tun Start Stop	,1/I	R1* R2*	
Sequence ID/ Work Center I 160 *1 AO*	D	Operation Description Identify as per dwg & Sto	ock Location:	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty		Reject Number	Insp. Stamp	DAS 36 9-89
Packaging Packaging		Memo		0.00							7 7	

170

QC21- Final Inspection - Work Order Release

0.00

\*170\*

Quality Control

Memo

0.00

MUS 14-05-11 MV 14-10.

DQA: Date:										A DT			
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				A E R O S P A C E
QA Closed:			Date:							W	ork Order up	odate only	
Work Orde	er:					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	,
	-				<del></del>	Rework	]		Skid-tube Crosstub	_اء	]	Water Jet	Engineering
Part N	10.					Scrap			Machining Small Fa	_	- Pro	d. Eng. Coor.	Quality
	-					Use-as-is			noforming Finishin		-{	re/Packaging	Other
NCR N	۱٥		·			Suspected Unapproved			Large Fab Composit	_	]	Supplier	
Root	$\neg$				Descr	ription of work order update		nitial	Action		Sign &		
Cause	1	Date	Step	Qty		or non-conformance	!	ief Eng			Date	Verification	QC Inspector
Design									· · · · · · · · · · · · · · · · · · ·				
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Handling/Pre									1				
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Offset/Setup													
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Training													
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							FA	ULT CA	TEGORY				
Landi	ng G	iear				General					_	-	_
	Щ	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Ш	Centre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ct	Temperature/Cure
	Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld	
	-	Cuffs				Contamination		ł	tions Incomplete/Unclear		Part Moved	_	Wrong Stock Pulled
Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong			
Heat Treat				Cut Too Short		Mislabe			Power Loss/	Surge	Other		
	Inspection Strip in Tube				Drawing	$ldsymbol{ld}}}}}}$	Misread	t					
	_	Marks/Ch				Drill Holes		Off-set					
		Turning Se	equence			Finish		Out of	Calibration				
	Wave/Twist in Tube					Fit/Function		Out of	Sequence				

Thursday, August 21, 2014 1:46:28 PM

Work Order ID: 123786

\*123786\*

\*D3463-042\*

Parent Item:

D3463-042

Parent Item Name: Step Weldment Assembly

**Start Date:** 8/21/2014

Required Date: 8/22/2014

Start Qty: 2.00

Required Qty: 2.00

**Comments:** 

IPP REV. A 05.11.18 new issue

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Ki	Total Qty	Qty Issued	Date Issued	Status	
238-806		Purchased	No			100	Each	114.0000	2	4				
*238-806* SS DOWEL PIN 1" LONG									**	-				
				Location		Loc	Oty	Loc Code						
				ST396			100				_			
					M127628		100				_			
				WA002			14		-	<u> </u>	_		140	182
				į	M120119		14		l	43	_		, ,	98
D3453-3		Manufactured	No			100	Each	25.0000	1	2				
*D3453-3*									**		-			
				Location	!	Loc	Oty	Loc Code						
				WA001			1		_		_		14	119-
				î	102797		1			12	_		14-	200
				WA002			24							VISU
					115648		5				_		•	
					121222		19				_			
D3453-5		Manufactured	No			100	Each	34.0000	1	2				
*D3453-5*	i								**					

Plug

Location	Loc Qty	Loc Code
WA001	15	
109132	15	
WA002	19	
109132	19	

DQA:			Date:											
						WORK ORDER NON-	-CC	ONFO	RMANCE / L				AEROSPACE	
QA Closed:			Date:							W	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
***************************************	-		<del></del>			Rework			Skid-tube	Crosstube	1	Water Jet	Engineering	
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	-	. '		<del></del>		Use-as-is			noforming	Finishing	=	e/Packaging	Other	
NCR N	١o.					Suspected Unapproved			Large Fab	Composite	<u>'</u>	Supplier		
											_			
Root					Desci	ription of work order update	1	nitial	Ad	ction	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector	
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Doc/Data														
Equip/Tooling														
Handling/Pre														
Material							l							
Operator						·								
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Process		i												
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Unapproved														
							FAI	ULT CAT	TEGORY					
Landi	ng G	iear				General					_		_	
		Bending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced	
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	ire .		Part Incorred	ct	Temperature/Cure	
		Crimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/L	Jnqualified	Part Lost/Mi	ssing	Weld	
, ,		Cuffs				Contamination		Instruct	ions Incomplete,	/Unclear	Part Moved		Wrong Stock Pulled	
<b>\'</b>		Crushing				Countersink		Misalig	ned/off center		Positioned V	/rong		
		Heat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
		Inspection	n Strip in	Tube		Drawing	·	Misread	<b>.</b>					
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of (	Calibration					
		<del>_</del>				Fit/Function		Out of 9	Sequence					

\*

Thursday, August 21, 2014 1:46:29 PM

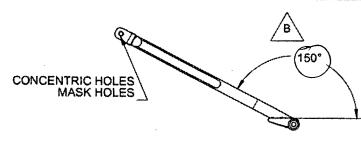
\*123786\* Work Order ID: 123786 D3463-042 \*D3463-042\* Parent Item: Parent Item Name: Step Weldment Assembly **Start Date:** 8/21/2014 Required Date: 8/22/2014 Start Qty: 2.00 Required Oty: 2.00 No 100 Each 3.0000 2 D3463-1 Manufactured \*\* \*D3463-1\* Arm Location Loc Qty Loc Code WA001 3 14-08-22 122331 3 100 Each 9.0000 D3463-3 Manufactured \*\* Step Location Loc Qty Loc Code 9 WA002 121236 9 D3463-5 100 Each 9.0000 Manufactured \*\* \*D3463-5\* End Cap Loc Qty Loc Code Location WA002 9 9 100476 100 4.0000 D3463-7 Each Manufactured<sup>\*</sup> \*\* \*D3463-7\* Drag Arm Location Loc Qty Loc Code WA002 113159

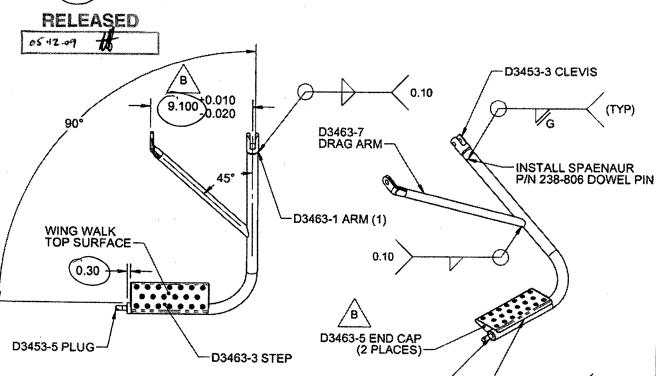
DQA:			Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / U				AEROSPACE		
QA Closed:			Date:							W	ork Order up	date only			
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS			
	•					Rework			Skid-tube	Crosstube		Water Jet	Engineering		
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
						Use-as-is		Therr	noforming	Finishing	Rec/Stor	e/Packaging	Other		
NCR 1	۱o					Suspected Unapproved			Large Fab	Composite	]	Supplier			
Root					Desci	ription of work order update	ı	nitial	Act	tion	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector		
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·							FAI	ULT CA	regory						
Landi						General		1			=1				
	Щ	Bending				Bend			rogram	ļ	Outside Dim	<u> </u>	Pressure/Forced		
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under		Set-up		
	$\vdash$	Cracks				Broken/Damage/Defect		Hardwa			Part Incorred		Temperature/Cure		
	Crimp/Kink/Ripple/Wave				Burrs			ion Incomplete/Ur		Part Lost/Mi	· ·	Weld			
	Cuffs				Contamination		ł	ions Incomplete/L	Jnclear	Part Moved		Wrong Stock Pulled			
Crushing					Countersink	$\overline{}$	1 -	ned/off center	<u></u>	Positioned V		·			
Heat Treat				Cut Too Short		Mislabe			Power Loss/	Surge	Other				
	Inspection Strip in Tube					Drawing	Misread								
	-	Marks/Ch				Drill Holes	$\vdash$	Off-set							
	-	Turning Se				Finish		1	Calibration						
	Wave/Twist in Tube					Fit/Function   Out of Sequence									



	DESIGI R		DRAWN BY RF	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANAD	
•	CHECK	ED#	APPROVED #	DRAWING NO. S	REV. B
	DATE	05.1	2.05	STEP WELDMENT	SCALE
	Α	0:	5.09.20	NEW ISSUE	
	В	0:	5.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

INSTALL P/N 238-806 DOWEL PIN /G MASK THREAD **AREA** 1.045





### NOTES:

- 1) WELD PER DART QSI 004
  2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
  BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
  3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  4) ALL DIMENSIONS ARE IN INCHES
  5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
  6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

D3463-042 STEP WELDMENT ASSEMBLY D3463-041 OPPOSITE

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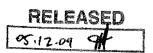
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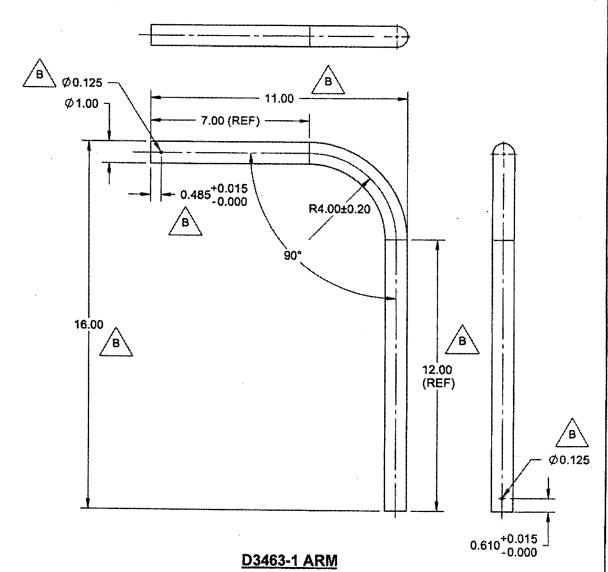
DQA:	<del></del>	Date:			WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:		Date:			WORK ORDER NON	-C(	ONFO	RMANCE / U		Vork Order u	pdate only	AEROSPACE		
Work Orde	r:				DISPOSITION	·			AGAINST [	EPARTMENT	/PROCESS			
Part No	0.				Rework Scrap Use-as-is Suspected Unapproved		Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				Desci	ription of work order update		Initial	Act	ion	Sign &				
Cause	Date	Step	Qty		or non-conformance		nief Eng		ription	Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	oling													
			L			FAI	ULT CAT	EGORY						
Landin	g Gear				General			<del></del>						
Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Instruct Misalig Mislabe Misread Off-set	re on Incomplete/Ur ions Incomplete/U ned/off center led	· -	Outside Dim Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss/	tolerance ct issing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other			
ļ	Wave/Twist in Tube				Fit/Function Out of Sequence									

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DESIGN RF	DRAWN BY RF	DART AEROSPA HAWKESBURY, ONTAR	
CHECKED	APPROVED #	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE <b>05</b> .1	12.05	TITLE STEP WELDMENT	SCALE 1:4





### NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120) 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

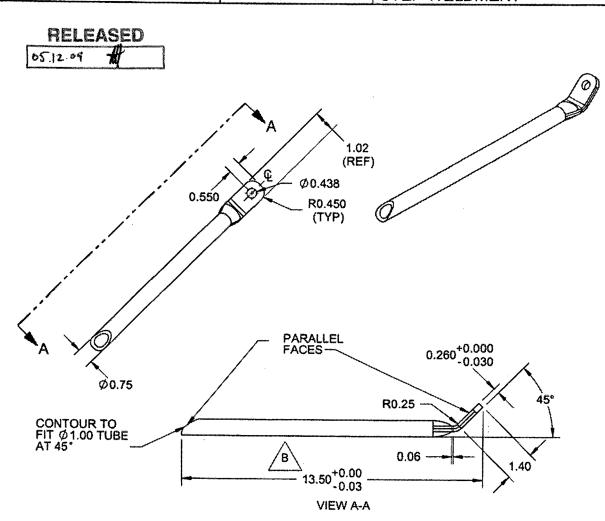
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DQA:		Date:		•	- WORK ORDER NON CONFORMANCE (LIREATE									DART
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only									AEROSPACE
Work Order:				DISPOSITION				DE	EPARTMENT/PROCESS					
Part No			<u> </u>	Rework Scrap Use-as-is Suspected Unapproved	Scrap Machining Small Fa Use-as-is Thermoforming Finishir		Crosstube Small Fab Finishing Composite	Prod. Eng. Coor. ng Rec/Store/Packaging				Engineering Quality Other		
Root		,		Desci	iption of work order update	1	Initial	Ac	ction		Sign &			
Cause	Date	Step	Qty		or non-conformance		ief Eng		cription		Date	Verification	1	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
<del></del>					,	FA	ULT CAT	EGORY						
Landin	_				General									
Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence			Bend BOM/Route Broken/Damage/Defect Burrs . Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration		/Unclear	•	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Se Te W	ressure/Forced et-up emperature/Cure /eld /rong Stock Pulled ther		
	Wave/Twist in Tube			Fit/Function		Out of Sequence								

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DESIGN RF	DRAWN BY RF	CE LTD D, CANADA	
CHECKED	APPROVED	D3463	REV. B SHEET 3 OF 4
DATE 05.	12.05	STEP WELDMENT	SCALE 1:4



# **D3463-7 DRAG ARM**

### NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120) 2) FINISH: NONE 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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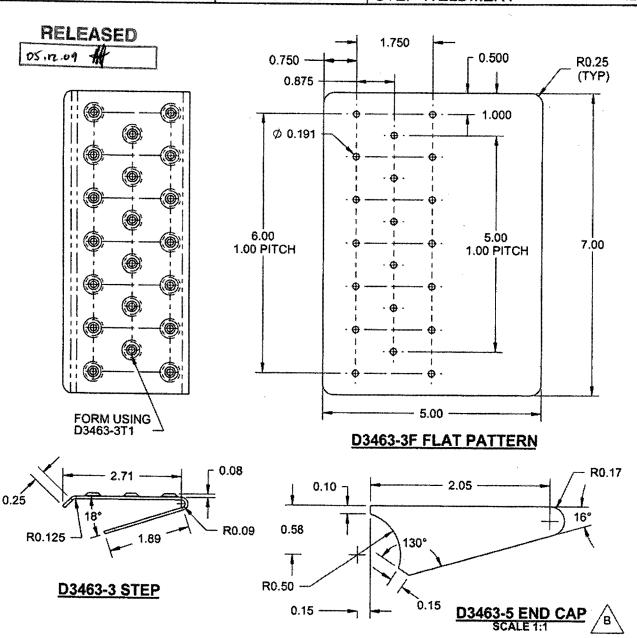
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DQA:	Date:			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:		Date:			WORK ORDER NON-	AERO	SPACE							
Work Order:					DISPOSITION				<b></b>					
Part No					Rework Skid-tube Crosstube  Scrap Machining Small Fab  Use-as-is Thermoforming Finishing  Suspected Unapproved Large Fab Composite		b Prod. Eng. Coor. Rec/Store/Packaging			Engineeri Qual Oth	ity			
Root De			Desci	ription of work order update	ı	nitial	Ac	tion		Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Insp	ector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
						FAI	ULT CAT	EGORY						
Landin	ng Gear			_	General		_		_			_		
	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence			Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration				Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge  Pressure/Forced Set-up Temperature/Cur Weld Wrong Stock Pulls Other				
	Wave/Twist in Tube				Fit/Function		Out of S	equence						

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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
CHECKED	APPROVED	DRAWING NO. D3463	REV. B SHEET 4 OF 4						
DATE 05.1	2.05	STEP WELDMENT	SCALE 1:2						



### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
  3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  4) ALL DIMENSIONS ARE IN INCHES
  5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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DQA:	Date:														
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only  Work Order update only										
Work Order:					DISPOSITION										
Part No					Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite		Prod. Eng Rec/Store/Pac		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
Root				Descr	iption of work order update	1	nitial	Ac	ction		Sign &			_	
Cause	Date	Step	Qty		or non-conformance		ief Eng	Desc	cription		Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved							5								
						FA	ULT CAT	EGORY							
Landin	<del></del> 1				General		1		ı		Ī				
-  -  -  -  -  -	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat			Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short		Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled			Positioned Wrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled				
-	_		Tuba	-		$\vdash$	i				Power Loss/	ourge	Other	$\dashv$	
	Inspection Strip in Tube  Marks/Chatter			Drawing Drill Holes		Misread Off-set									
-	Turning S				Finish	_	1	Calibration			Mile is				
	Wave/Twist in Tube				Fit/Function		Out of Sequence				·				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH